

Date: Wednesday, 16/08/2006 7:41:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 28193	
Estimate Number : 10746	
P.O. Number : N/A	Part Number : D34633
This Issue : 16/08/2006 S.O. No. : N/A	Drawing Number : D3463 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28193	Material : N/A
Written By : _____	Due Date : 23/08/2006 Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : EST REV. A 05.11.18 NEW ISSUE EC	
Est Rev:B Now on Waterjet 056-08-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.2552 sf(s)/Unit Total : 2.5515 sf(s)
 304/316 .063 Sheet
 (m304s16ga)
 Batch: M19059

M19059 *06 08 16*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3463
 Dwg Rev: B
 Prog Rev: B

M19059 *06 08 16* *(10)*

2-Deburr if necessary

SAD 06:08:16 *(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:16 *(10)*

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

06-08-16 *(10)*

Date: Wednesday, 16/08/2006 7:41:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28193

Part Number: D34633

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form Dimples as per Dwg D3463 using DT3463-3T1

2-Deburr

3-Form as Dwg D3463.

SB 06/09/01

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 09.05 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 83

06/09/05 (10)
06/09/05 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/09/06

Job Completion



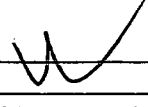

CL 06/09/05

Sept - 1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:20:11 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 28193	
Estimate Number : 10746	
P.O. Number :	Part Number : D34633
This Issue : 15/08/2006 S.O. No. : .	Drawing Number : D3463 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL/MED FAB	Drawing Revision : B
Previous Run : 27535	Material :
Written By : 	Due Date : 31/08/2006 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : EST REV. A 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:

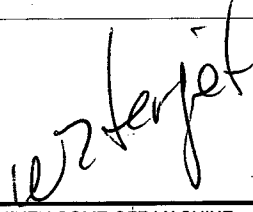


Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.2552 sf(s)/Unit Total : 2.5515 sf(s)
304/316 .063 Sheet
(m304s16ga)
Batch: _____



2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form Dimples as per Dwg D3463 using DT3463-3T1

2-Deburr

3-Form as Dwg D3463.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:20:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28193

Part Number: D34633

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



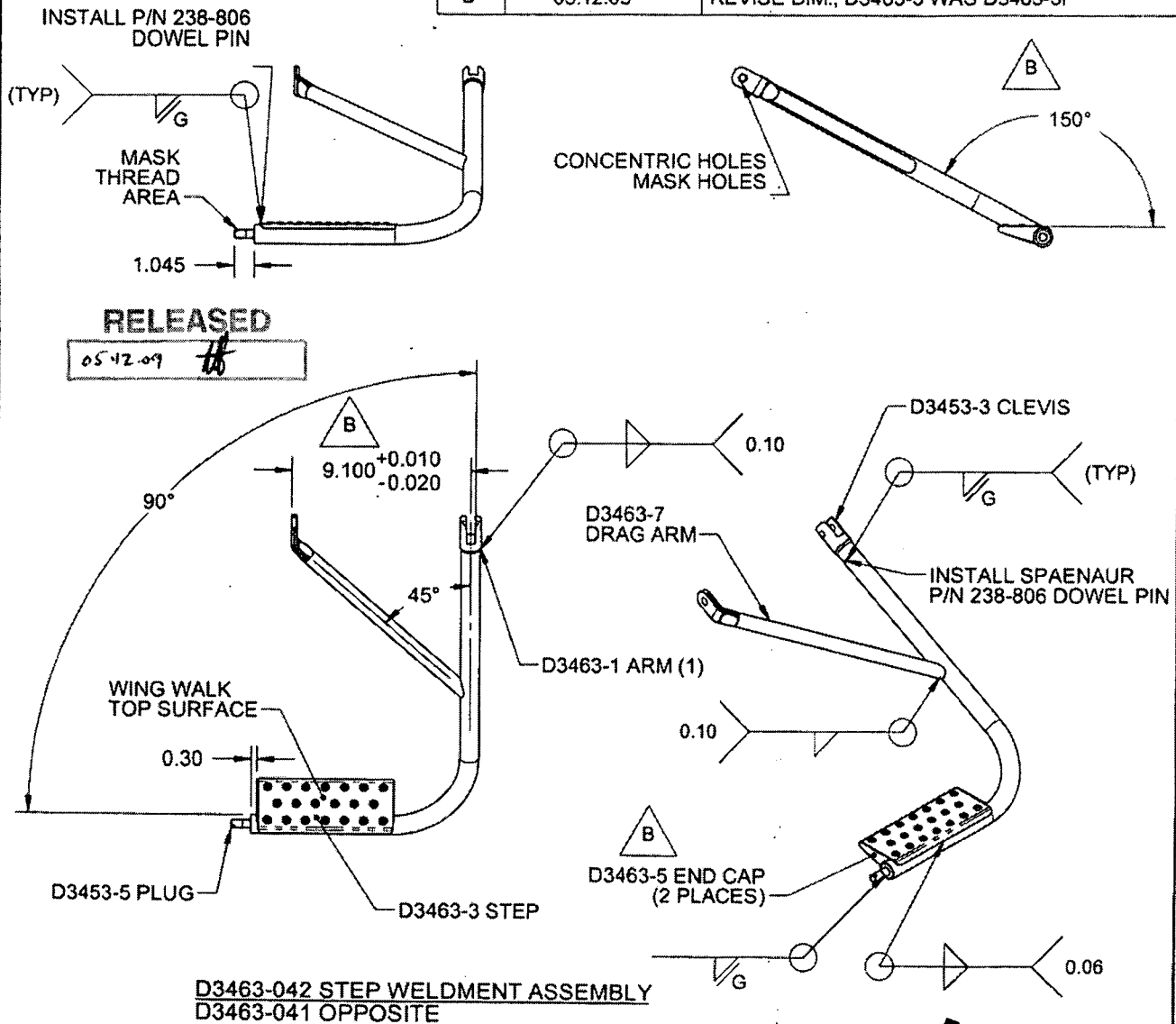
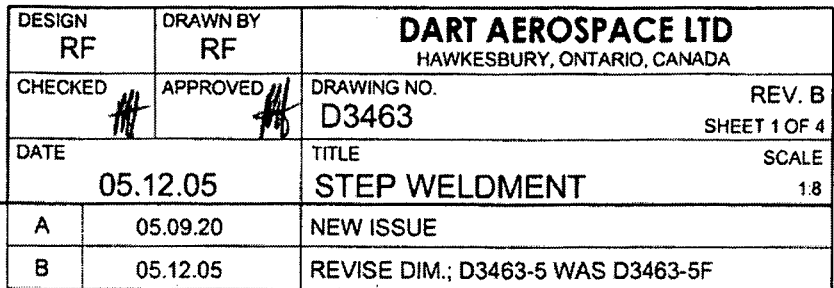
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

REFERENCE ONLY

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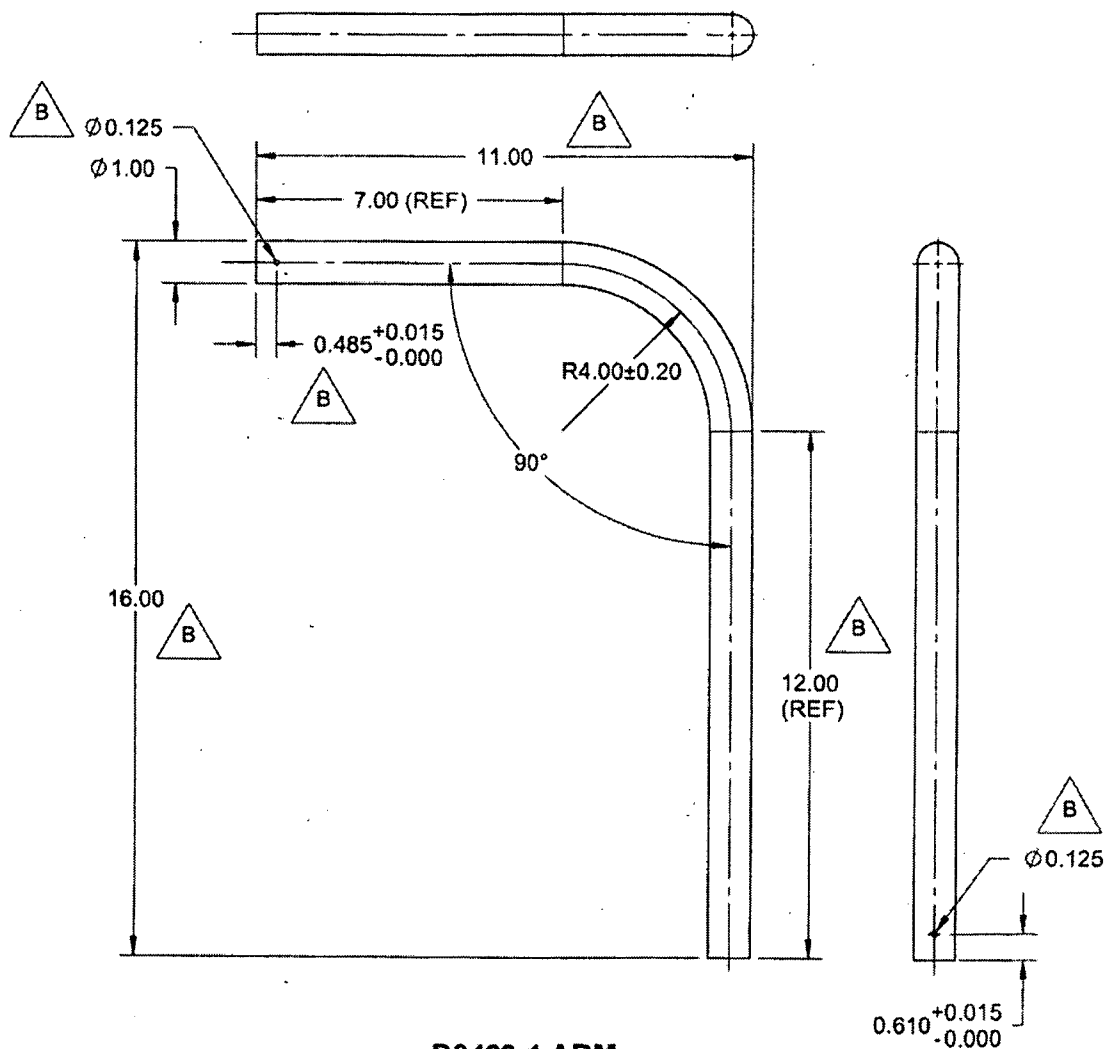
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.09



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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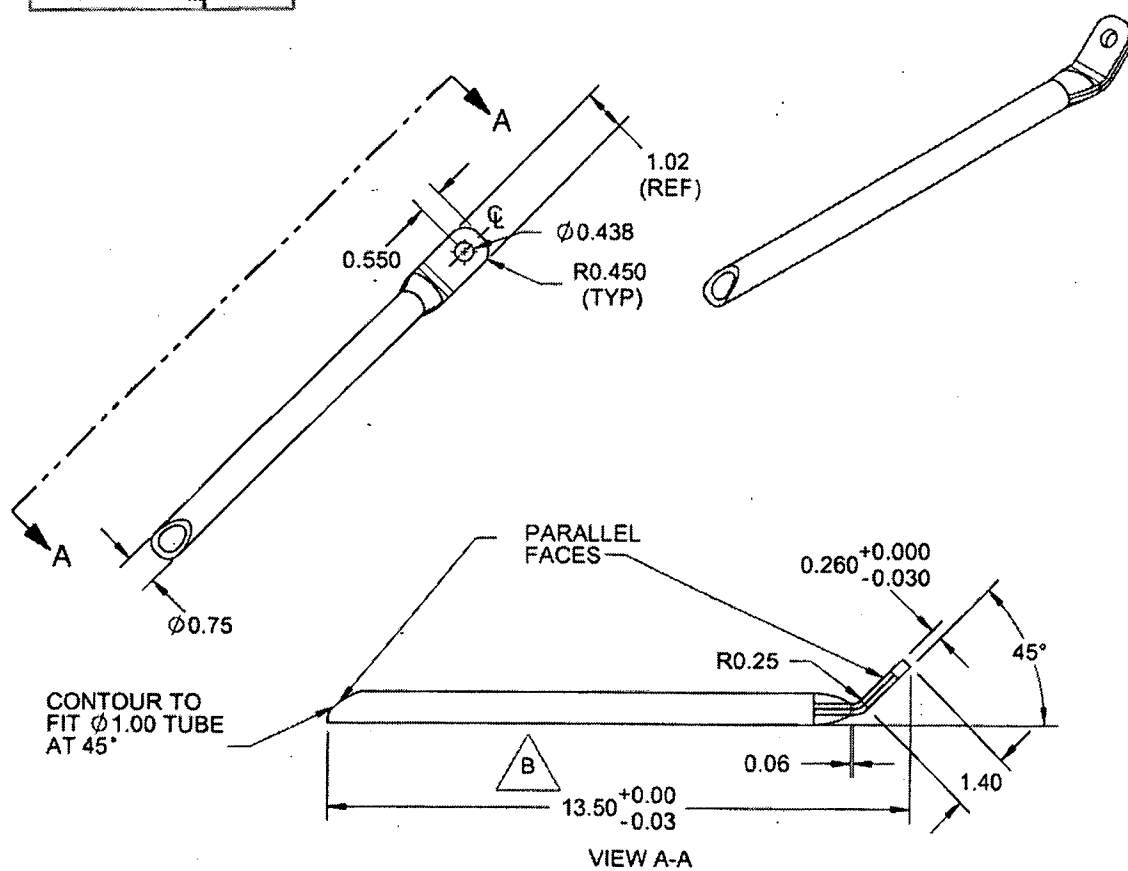
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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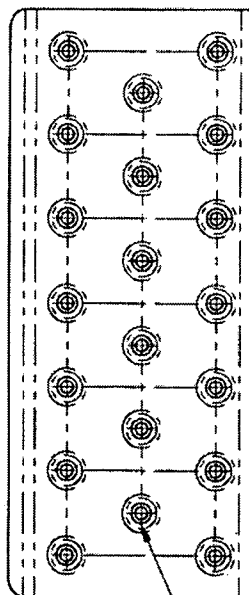
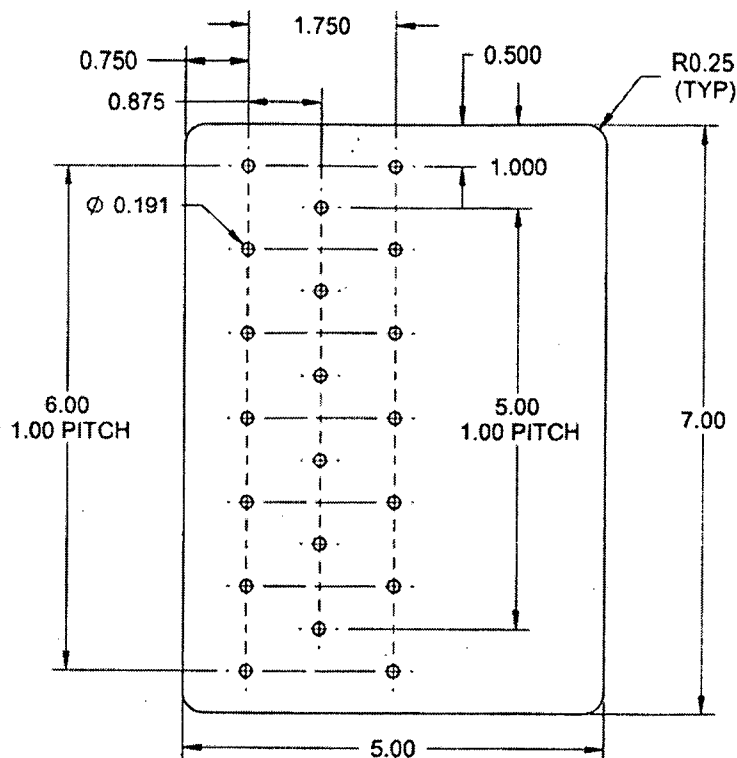
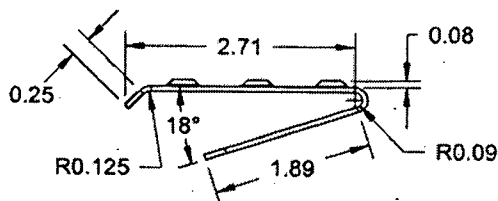
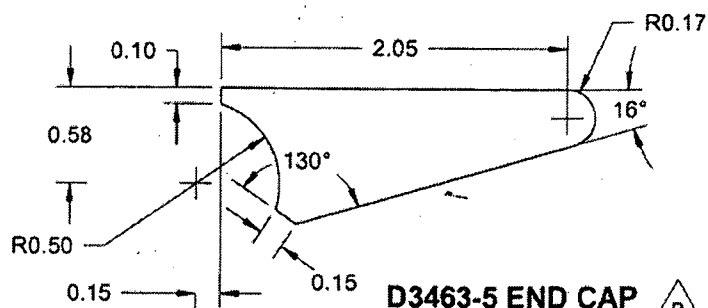
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

05.12.05 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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